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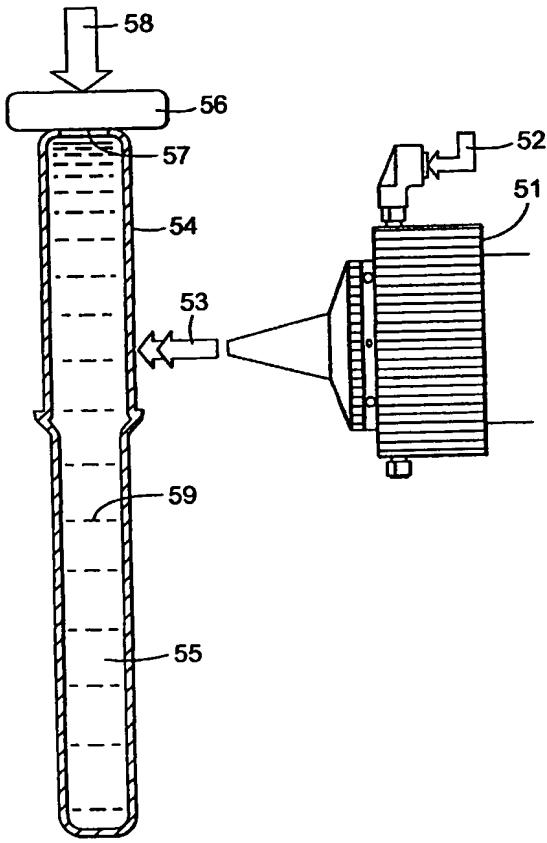
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## (54) Title: MANUFACTURE OF VALVE STEMS



(57) Abstract: A method for providing a hole into a valve component having an internal cavity (55), said method comprising the steps of filling and sealing a fluid (59) within said cavity; and laser drilling the hole through the component into the internal cavity. Said method is particularly advantageous for providing a side port into a valve stem (54). The present invention also relates to a method of manufacturing a valve stem, said method comprising the steps of: a) providing a valve stem work-piece having a passageway with an outlet (57); b) filling the passageway with a fluid; c) sealing the outlet; d) laser drilling a side port through the work-piece into the passageway; and e) unsealing the outlet.

WO 2004/002672 A1